

PACKAGE TICKET

(DRY AND PASTE ONLY)

LOT F-7022

PQ

8-10

STUMP

262

PKG. N-CODE _____

WHSE. OPER.

23

142.4
146.4
145.4
132.4
159.4
172.4
155.4
144.4
178.4
154.4
157.4
161.4
155.4
148.4
167.4
134.4
137.4
2596.7

PRODUCT NAME = "DON" RED DARK

NON-BLEEDING

CG 36 CODE RT-695-D PKG

PROCESSES APPROVED BY

RT-695-D (N)

ALTERNATE(M)

TYPED BY JLC 3-1-81

LOT MAY -0-81-21422

MAKING NOTES

EST'D WGT 2781 LBS

TOTAL EST'D WGT= LBS (CRT ENTRY)

JOB NAME: 36RT695DPN

INSTRUCTIONS

PRESSING

RECORD

DATE 107 5-29
TIME 3:25 AM
RELEASED BY A.C.
PRESS 36 33 35 38
NO. OF Cakes 60 60 60 60
PRESS WITHOUT AGITATION
WASH TO 4000 OHMS WITH 35-75F WATER
TEST AFTER 16 HOURS
LOAD ON 12 CARS

	1ST	2ND	3RD	4TH	5TH
PRESSLOAD	10 AM				
STARTED					
CAKES USED	60				
WATER ON	10 PM				
HRS. WASHED	16				
OHMS	4,000				
HRS. WASHED					
OHMS					
HRS. WASHED					
OHMS					
CAKE CONDITION					
NO CARS LOADED					
EXPLAIN LOSSES					

SAMPLES JAR
DELIVER TO CTL FOR COLOR

SAMPLED BY
RELEASED BY JLC

DRY 24 HOURS AT LV HV
TEMP. 180 F

SE 15-30
MN COLOR

DRYING

LUMP: - OK - WET - SALTS - CONTAMINATED

No record of any processing
losses.

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO CARS PULLED
SAMPLED BY
RELEASED BY

NO DRUMS 15
LUMP WGT 2623

MILL 5 HSP 1/8" RP SCREEN 4600 RPM
MAX. TEMP. 150 F
MN COLOR

SCREEN RPM
MAX. TEMP. F

IF FOLLOWING RT-531-D/RT-539-D CLEAN
MILL THOROUGHLY; CHANGE BAG & HOSE
DOWN EXHAUST SYSTEM. NAPHTHANIL
CAUSES BAD TOLUOL BLEED.

EXPLAIN LOSSES

SAMPLE AFTER/WITHOUT MIXING

DATE MIXED

SAMPLES: ENVELOPE & 2 PINT CANS
DELIVER TO CTL

SAMPLED BY
RELEASED BY 6/9/81

1422
5100
124

0.00 *

1.97 +
0.12 -
1.88 +
0.12 -
1.92 +
0.12 -
1.99 +
0.12 -
2.01 +
0.12 -
1.85 +
0.12 -
1.93 +
0.12 -
1.93 +
0.12 -
1.87 +
0.12 -
1.97 +
0.12 -
2.03 +
0.12 -
1.99 +
0.12 -
1.86 +
0.12 -
1.78 +
0.12 -
1.05 +
0.12 -
26.23 *

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 107

C.V. 100

D.V. 330,322,207 317 100

CG 36 CODE RT-695-D PKG

PROCESSES APPROVED BY

MAY 28 E1422

() RT-695-D (N) JIG 3/18/81

(DATE) (LOT NUMBER)

(M) ALTERNATE () (ok)

TYPED BY: JLC

ESTIMATED WGT 2781 LBS. STANDARD HRS. TIME M

PREPARATION NOTES:

EQUIP MENT	NAME: "BDN" RED DARK	USE LBS	N-CODE	ACCT LBS
PREP 1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15#		777-A	
	OBTAIN FOR S 6		740-C	
	OBTAIN FOR S 42		253-C	
317 2	RUN 23" (748G) WATER INTO V-317 50.28	428	7-D	215
	WEIGH & POUR IN		740-C	1096
	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2			
	LOT 100% 97.5 98.4 99.4	991 122		
	WEIGH ON POSTAL SCALE & ADD LOT	8	584-C	8
	DUMP IN	50	113-B	50
	DUMP IN	10	777-A	10
	HEAT TO 214-216 DEG. F WATCH FOAM			
	RECORD: BY + (+), IF NECESSARY ADJUST			
	TO + BY > ASSUME 50%		7-D	
	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT			
	OFF STEAM WATCH FOAM			
	NOTE RECORD: SPARKLER PRESSURE 0 PSI			
	IF NOT ZERO, NOTIFY SUPERVISOR			
	CIRCULATE 15 MIN OR LONGER THRU SPARKLER			
	UNTIL SOLUTION IS CLEAR			
	MAINTAIN AT 190-195 DEG. F FOR S 15			
	RECORD: HT. DEG. F & RECORDER 190 DEG. F			
	RECORD: START 0.00 TOTAL MIN 5 CLARITY CLEAR			
100 3	RUN #1 (99G) WATER INTO V-100			
	WHEN S-13 COMPLETE, PUMP V 317 THRU			
	SPARKLER: MAINTAIN V-317 AT 190-195 DEG. F			
	RECORD: START 10.2 TOTAL MIN 25			
	SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK			
317 4	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET &			
	STOP PUMP			
	RUN IN 12" (215G) WATER & HEAT TO 190-195			
	DEG F			

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT _____ DEG. F & RECORDER RECORD: START _____ TOTAL MIN <u>10</u> CLARITY <u>CLEAR</u>			
100 5	19	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100			
	20	RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F			
	21	CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100			
	22	WHEN MT, BLOW OUT SPARKLER INTO V-100			
	23	HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH)			
	24	IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
	25	IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26			
100 6	26	ADJ TO 16" (1590G)			
	27	HEAT V-100 TO 165-170 DEG. F			
	28	RUN IN V-324 THRU DIRECT M. <u>2</u> <u>3200</u> % <u>1384</u>		28-D	443
		LINE AND RINSE IN			
	29	STIR 15 MIN AT 165-170 DEG. F			
	30	ADJ TO 50" (4970G) AT 34-38 DEG. F RECORD: TEMP <u>34</u> DEG. F AND IF NECESSARY 50X330		57-A	
		ADJ TO 34-38 DEG. F & RECORD: TEMP _____ DEG. F		57-A	
107 7	31	RUN 45" (4320G) WATER INTO V-107			
	32	TURN ON AGITATOR AND STEAM AND DUMP IN	1400	336-B	1400
	33	DUMP IN	250	65-A	250
	34	HEAT TO 150-160 DEG. F AND STIR			
	35	RECORD: PH <u>6.6</u> (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER ASSUME 78%		27-D	<u>2</u>
	37	RECORD: PH <u>5.3</u>			
	38	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	39	HOLD FOR S 58			
207 8	40	RUN IN 47" (1610G) WATER INTO V-322			
	41	WEIGH AND POUR IN M. <u>9</u> <u>50.28</u> % <u>935</u>		7-D	470
	42	DUMP IN FROM S 3 LOT		253-C	930
		<u>Dropped into</u> <u>OK per</u> <u>334</u> <u>V-107</u> <u>E.W.K.</u> <u>24</u>			
		WEIGH ON POSTAL BALANCE AND ADD LOT <u>8500</u>	24	180-C	24

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
322 8	44	HEAT TO 70-90 DEG. F			
207	45	STIR IN IN ONE TO TWO MINUTES	27	567-B	27
	46	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
313/ 302 9	47	WEIGH & POUR INTO V- <u>312</u> FOR S 50			
		<u>32.93</u> % <u>1108</u>		725-A	365
322 10	48	ADJ V-322 TO <u>45</u> (2240G) AT 77-80 DEG. F			
207	49	RECORD: TEMP <u>78</u> DEG. F			
	50	SLURRY WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN.	160	39-A	160
100 11	51	RUN IN N-725-A FROM S 47 AFAP INTO V-100			
	52	STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI		57-A	
	53	RECORD: TIME START <u>7:35 AM</u> + KI <u>+</u> TEMP <u>37</u> DEG. F			
		NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32%		28-A	
		RECORD: CR <u>+</u> , KI <u>+</u>			
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS ASSUME 33%		725-A	
		RECORD: CR <u>+</u> , KI <u>+</u> TEMP <u>37</u> DEG. F			
53	54	COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16" DRIFICE)			
	55	RECORD: START <u>8:15 PM</u> TOTAL MIN <u>115</u>			
54	56	WHEN S 53 COMPLETE STIR 15 MIN			
55	57	RECORD: DIAZO <u>-</u> (-), BASE <u>+</u> (+) PH <u>6.7</u> (7.0-8.0) TEMP <u>62</u> DEG. F (60-65 F)			
		NOTE: (1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP ASSUME 50%			
		(2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D AND N-7-D)			
56	58	ADJ TO PH 9.0-9.5 (SEE ATTACHED PH ADJ AID) ASSUME 32%			
		1) IF PH IS 6.5-7.0, WEIGH 40# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>7.3</u> (9.0-9.5)			
		2) IF PH IS 7.0-7.5, WEIGH 35# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>7.4</u> (9.0-9.5)			
		3) IF PH IS 7.5-8.0, WEIGH 30# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>7.0</u> (9.0-9.5)			

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
100		4) IF PH IS 8.0-8.5, WEIGH 10# AS IS N-7-D			
11		POUR INTO 50 GAL WATER (1/2 FULL) IN PT &			
CONT		RUN INTO CV 100 IN 15 MIN. STIR 5 MIN &			
		RECORD: PH_____ (9.0-9.5)			
		5) IF PH IS 8.5-8.9, WEIGH 5# AS IS N-7-D			
		POUR INTO 50 GAL WATER (1/2 FULL) IN PT &			
		RUN INTO CV 100 IN 15 MIN. STIR 5 MIN &			
		RECORD: PH_____ (9.0-9.5)			
		6) IF PH IS ABOVE 9.5, DO NOT ADJUST			
57		RECORD: PH_____ ASSUME 50%		7-D	
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS			
		TO APPROACH PH 9.0-9.5 THEN USE			
		LESS N-28-D			
		(CONCENTRATED N-28-D & N-7-D AND TOO LOW			
		COUPLING TEMPERATURE CAUSES MASSTONE TO			
		BE TOO LIGHT)			
58		SHUT OFF AGITATOR			
=====					
107	59	DURING S 53 HEAT V-107 TO 210-212 DEG. F			
112		& SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-			
		212 DEG. F PRIOR TO START OF STRIKE			
60		PUMP V-100 INTO V-107 IN 70-75 MIN.			
		LET V-107 TEMP DROP TO 200-205 DEG. F			
		DURING STRIKE THEN MAINTAIN AT 200-205 DEG.			
		F FOR BALANCE OF STRIKE WITH AGITATOR SHUT			
		OFF IN V-100			
		RECORD: START <u>1245A</u> TOTAL MIN <u>1.5</u>			
61		WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG. F			
62		STIR 15 MIN AT 210-212 DEG. F			
63		FLOOD TO 180-190" (18240G)			
		RECORD: PH <u>6.5</u> (6.5-7.2) AND STOP			
		AGITATOR			
		SAMPLE - 1 gal			
		START FINISH OPERATOR			
		<u>7:00</u> <u>3:00</u> <u>301</u>			
		<u>3:00 PM</u> <u>11:40 PM</u> <u>37</u>			
		<u>11:40 PM</u> <u>3:00 PM</u> <u>372</u>			



